

Work Order ID 150388

Wednesday, August 24, 2016 11:49:44 AM

150388

Page 1

Item ID: D3884-2

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle, Inside RH

Start Date: 9/6/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 9/12/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

DAS

21

9-89

Date: AUG 29 2016

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3884	C								

100

0.03

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

HAAS CNC vertical machine #1

Memo

0.95

Program Batch No.

B150388

Double check by:

1-Machine Step No 1 per Folio FA819 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA819 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA819 and inspect per Dimension Sheets

L.A. 16/09/15

6 0

DAS
08
9-89

110

0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.01

L.A. 16/09/15

6 0

DAS
08
9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By 	
								Lead hand / Supervisor Approval Verification 	
QC / QA Coordinator Approval 									

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Work Order ID 150388

Wednesday, August 24, 2016 11:49:44 AM

150388

Page 2

Item ID: D3884-2**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** Saddle, Inside RH**Start Date:** 9/6/2016 **Start Qty:** 6.00***6*****Cust Item ID:****Required Date:** 9/12/2016 **Req'd Qty:** 6.00***6*****Customer:****Reference:****Approvals:****Process Plan:** _____**Date:** _____**Tooling:** _____**Date:** _____**Run Start*****NR1*****QC:** _____**Date:** _____**SPC (Y/N):** _____**Date:** _____**Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.02

Quality Control

DAS

33

9-89

16/07/17

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.12

Hand Finishing

X6RH

✓

2516/09/19

BEB

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐			No Re-verification ☐	Pressure/Forced ☐			Temperature/Cure ☐
Design ☐			Operator ☐	Bending ☐			Set-up ☐
Doc/Data ☐			Offset/Setup ☐	Centre Not Concentric ☐			BOM/Route ☐
Equip/Tooling ☐			Supplier ☐	Cracks ☐			Broken/Damage/Defect ☐
Handling/Pre ☐			Training ☐	Crimp/Kink/Ripple/Wave ☐			Inspection Incomplete/Unqualified ☐
Material ☐			Use for Testing ☐	Cuffs ☐			Contamination ☐
Internal Transport ☐			Poor Information ☐	Crushing ☐			Countersink ☐
Tribal Knowledge ☐			Rushing ☐	Heat Treat ☐			Cut Too Short ☐
LOA ☐			Product Improvement ☐	Wave/Twist in Tube ☐			Instructions Incomplete/Unclear ☐
Substation ☐			Process Improvement ☐	Marks/Chatter ☐			Drill Holes ☐
Past Expiry Date ☐			Manufacturing Process ☐	OTHER : _____ _____ _____			
Misidentified ☐			Past Due ☐				

Work Order ID 150388

Wednesday, August 24, 2016 11:49:44 AM

150388

Page 3

Item ID: D3884-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Inside RH
Start Date: 9/6/2016 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 9/12/2016 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
140									

Powdercoat
Powder Coating

Memo 0.03

MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT AS PER INDICATED ON DWG (SEE NOTE 2)

M 135412

DO NOT MASK INSIDE FLANGE SURFACE

START TIME: 8:55
OVEN TEMPERATURE: 320°
FINISH TIME: 9:25

6 16-09-20 DAS 34 9-89

150	QC3- Inspect Part Finish	0.00							
150									

QC
Quality Control

Memo 0.01

6 38 9-89

SEP 20 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				OTHER : _____			

Work Order ID 150388

Wednesday, August 24, 2016 11:49:44 AM

150388

Page 4

Item ID: D3884-2**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** Saddle, Inside RH**Start Date:** 9/6/2016 **Start Qty:** 6.00***6*****Cust Item ID:****Required Date:** 9/12/2016 **Req'd Qty:** 6.00***6*****Customer:****Reference:****Approvals:****Process Plan:****Date:****Tooling:****Date:****Run Start*****NR1*****QC:****Date:****SPC (Y/N):****Date:****Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

160

Identify as per dwg & Stock Location: SK404

0.00

160

Packaging

Memo

0.01

Packaging

6 DAS
6
9-89SEP 2 1 2016

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.10

Quality Control

DAS
21
9-89SEP 2 2 2016DAS
21
9-89SEP 2 2 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
1				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Wednesday, August 24, 2016 11:49:43 AM

Page 1

Work Order ID: 150388

150388

Parent Item: D3884-2

D3884-2

Parent Item Name: Saddle, Inside RH

Start Date: 9/6/2016

Required Date: 9/12/2016

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP RevA: New issue DD verified by:EC

IPP REV:B

15.05.20 remove inside powdercoat DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-017

Manufactured

No

Each

41.0000

6

D6101-017

Saddle Billet

Location

Loc Qty

Loc Code

MAT046

41

144956

31

149294

10

6

mf
16/09/14

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : _____							

DART AEROSPACE LTD		Work Order: 150388
Description: Saddle, Inboard, RH		Part Number: D3884-2
Inspection Dwg: D3884	Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		0.647	0.647	0.647	0.647		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		0.259	0.259	0.259	0.259		
F	0.605	0.625		0.615	0.615	0.615	0.615		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.000	2.000	2.000	2.000		
J	0.140	0.175		0.152	0.152	0.152	0.152		
K	1.265	1.285		1.265	1.265	1.265	1.265		
L	0.115	0.135		0.125	0.125	0.125	0.124		
M	0.240	0.260		0.250	0.250	0.250	0.250		
N	0.110	0.140		0.132	0.132	0.132	0.132		
O	0.240	0.260		0.251	0.250	0.250	0.250		
P	2.826	2.886		2.856	2.856	2.856	2.856		
Q	0.178	0.198		0.188	0.188	0.188	0.188		
R	0.140	0.165		0.149	0.150	0.149	0.149		
S	0.720	0.780		0.755	0.755	0.755	0.755		
T	1.220	1.280		1.256	1.256	1.256	1.256		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		6.000	6.000	6.000	6.000		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510		0.497	0.499	0.499	0.499		
Y	0.020	0.040		0.030	0.030	0.030	0.030		
Z	0.313	0.318		0.314	0.314	0.314	0.314		
AA	0.760	0.765		0.764	0.764	0.764	0.764		
AB	0.215	0.220		0.219	0.219	0.219	0.219		
AC	0.316	0.321		0.316	0.316	0.316	0.316		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010		1.000	1.000	1.000	1.000		
AF									
Accept/Reject									

Measured by: <i>AS</i>	DAS
Date: 16/09/15	08

Audited by: <i>AS</i>	33
Date: 11/01/17	9-89

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	15.09.09	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 150388
Description: Saddle, Inboard, RH		Part Number: D3884-2
Inspection Dwg: D3884	Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	16	7	4		
A	2.870	2.880		2.875	2.875				
B	1.433	1.443		1.438	1.438				
C	0.638	0.658		0.647	0.647				
D	3.895	3.905		3.900	3.900				
E	0.257	0.262		0.259	0.259				
F	0.605	0.625		0.615	0.615				
G	1.120	1.130		1.125	1.125				
H	2.245	2.255		2.250	2.250				
I	2.000	2.020		2.000	2.000				
J	0.140	0.175		0.152	0.152				
K	1.265	1.285		1.265	1.265				
L	0.115	0.135		0.125	0.125				
M	0.240	0.260		0.250	0.250				
N	0.110	0.140		0.132	0.132				
O	0.240	0.260		0.250	0.250				
P	2.826	2.886		2.856	2.856				
Q	0.178	0.198		0.188	0.188				
R	0.140	0.165		0.149	0.150				
S	0.720	0.780		0.755	0.755				
T	1.220	1.280		1.256	1.256				
U	1.245	1.255		1.250	1.250				
V	5.990	6.010		6.000	6.000				
W	2.495	2.505		2.500	2.500				
X	0.490	0.510		0.499	0.499				
Y	0.020	0.040		0.030	0.030				
Z	0.313	0.318		0.314	0.314				
AA	0.760	0.765		0.764	0.764				
AB	0.215	0.220		0.219	0.219				
AC	0.316	0.321		0.316	0.316				
AD	1.745	1.755		1.750	1.750				
AE	0.990	1.010		1.000	1.000				
AF									
Accept/Reject								DAS	
								33	
								9-89	

Measured by: B.A.	DAS
Date: 16/09/15	08
	9-89

Audited by:	
Date: 16/07/17	

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	15.09.09	Dwg Rev updated	KJ	

8

7

6

5

4

3

2

1

0.015

THIS COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

150388 ML5

16-08-29

0.050 X 45°
CHAMFER
2 PL0.175
0.140

0.625

R2.000

+0.020

-0.000

E A7-4

F B6-4

45°

0.896

2.08
REF

81.1°

0.853
REFBORE
C0.140
0.110
TYP

0.615

1.125±0.005

2.250±0.005

GRAIN
DIRECTIOND3884-2
BXXXXX

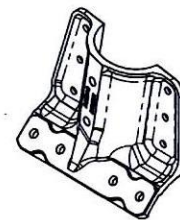
2.875±0.005

1.438±0.005

0.648

Ø0.257^{+0.005}
_{-0.000}
6 PLBORE
C

3.900±0.005



D3884-2 SADDLE, INBOARD RH

NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO
MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.03 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD R0.250
- 9) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D3884-2-REVC.SLDPRPT"

RELEASE
15 MAY 19

APPROVED

DESIGN	AP
DRAWN	AP
CHECKED	AJS
MFG. APPR.	JLM
APPROVED	HS
DE APPR.	DS
DATE	15.02.11

DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO.	REV. C
D3884	SHEET 3 OF 4
TITLE	SCALE
INBOARD SADDLE	NTS

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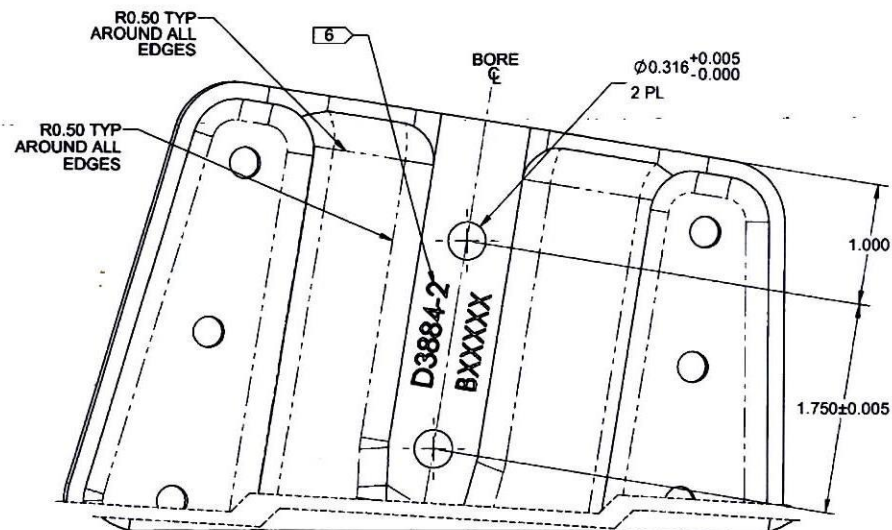
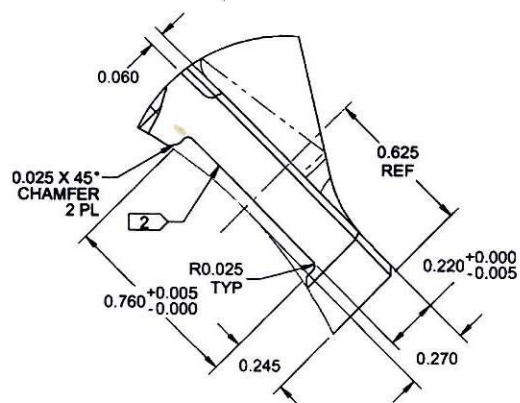
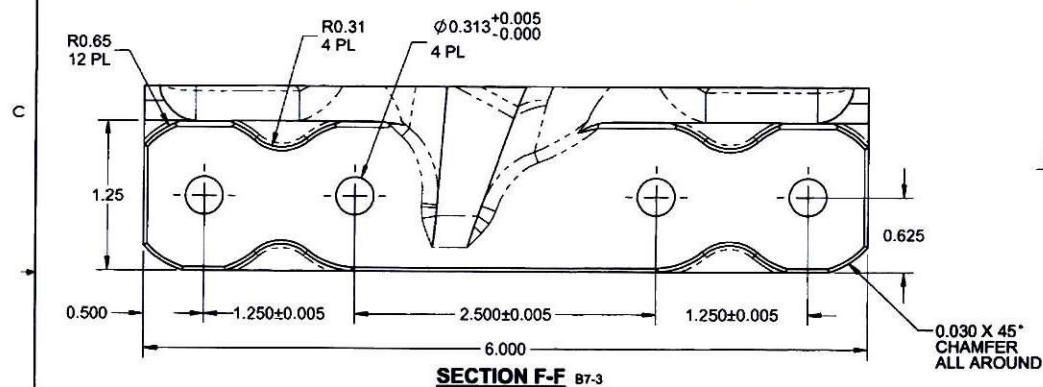
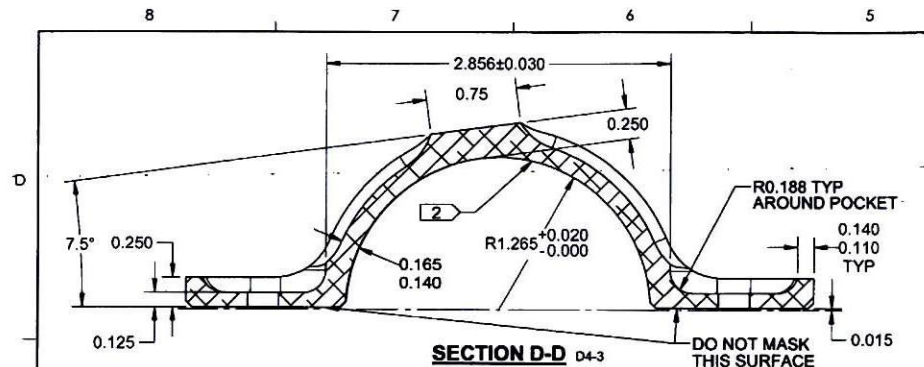
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4

3

2

1



RELEASED
APR 2015 MAY 19

APPROVED	DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
	DRAWN	AP		
	CHECKED	AJS	DRAWING NO.	REV. C
	MFG. APPR.	JLM	D3884	SHEET 4 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	INBOARD SADDLE	NTS
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